

Date: Monday, 05/01/2009 3:23:34 PM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD X-TUBE EXT HEIGHT(-013)  
 Job Number : 44381  
 Estimate Number : 10565  
 P.O. Number :  
 This Issue : 05/01/2009 S.O. No. :  
 Prsht Rev. : NC Part Number : D205596105  
 First Issue : / / Type : CROSSTUBES Drawing Number : D205596105  
 Previous Run : 44380 Project Number : N/A  
 Material : B  
 Due Date : 23/01/2009 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JD 09.01.05  
 Comment : Est Rev:D 05.03.21 Added bending procedure KJ/JLM  
 Est Rev:E 08-01-10 ECN 1075 DD  
 Est Rev F 08.04.28 Added bending & mat'l EC  
 verified by: DD

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JD 09/02/02



Comment: DOCUMENT CONTROL ECN 09-524 added 09/02/08  
 Photocopy D205-594 bluefile & type labels per PPP D205-596-105 CHG002

2.0 D6005180 Crosstube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
 Crosstube Material  
 batch: B-38345 MB 09-03-09 (1)

3.0 BENDING CROSS BENDING MACHINE - CROSSTUBES



Comment: BENDING MACHINE - CROSSTUBES

Bend as per Dwg D2889 using CNC bender program

DP 9-3-9

4.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Mark 23.92" for cutting from tangential line in the straight section from D2889 as per Dwg wall template.

DP 9-3-9

5.0 QC15 DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

09.03.10 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 44381

Part Number: D205596105

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut as per Dwg D205-596-105

MB

09-03-10

①

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube. 46119-3-10

7.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

09-03-10 ①

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

MB

09-03-12

Chemical Conversion Coat per QSI 005 4.1

9.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

RT 09 03 17 PTO

1-Prime inside and outside with Immron per QSI 005 4.2

10.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

MA 09 03 18

①

11.0

D3595063450

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

RUBBER CUSHION

batch 43210

RT 09-03-19

12.0

MS2192025

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp(per MIL-DTL-8783C)

batch 109644

RT 09-03-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-03-17	9.0	1- prime + paint as per Dart QSR 0054.2	IT	09-03-17		<i>[Signature]</i> 09-03-17	<i>[Signature]</i> 09-03-17

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: FWD X-TUBE EXT HEIGHT(-013)

Job Number: 44381

Part Number: D205596105

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D28931

2.75 Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2893-1

Support

42353

RT 07-03-19

14.0

CROSTUBES

CROSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2- Apply magnobond 6398 as per dwg D205-596-105

Magnobond 6398 Batch: 107900

EXP: 09-09-19

RT 09-03-19

3- Install supports and clamps per Dwg D205-596-105. Torque clamps to 80-100 in lb. as per dwg

RT 07-03-20

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/03/23 @

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-596-105

Location:

PPP Rev: 5

9/13/23

(K)

SP

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



mf 09-03-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

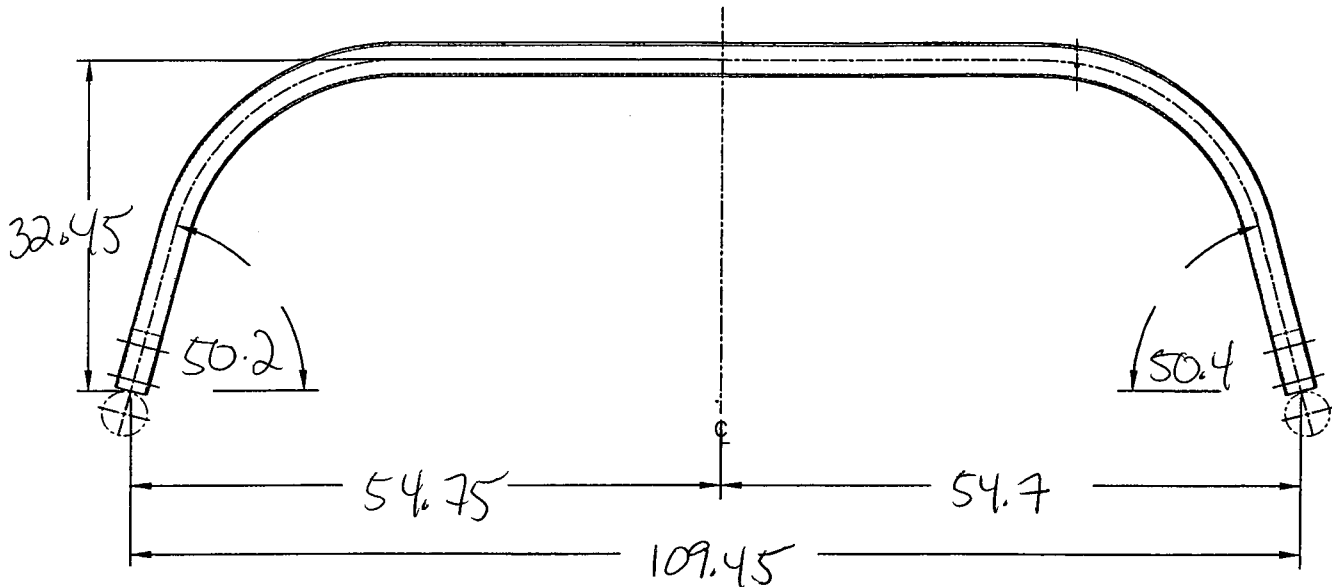
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	H4381
Description: Crosstube High-High Fwd		Part Number:	D205-596-105
Inspection Dwg: D205-596-105      Rev: B			Page 1 of 1

Required Dimension	Min	Max
Height	32.4	32.6
1/2 Span	54.6	54.8
Angle	49	52
Total Span	109.2	109.6



Comments

QC15 Inspection	<i>[Signature]</i> 09.03.10
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	<i>[Signature]</i>
B	08.04.21	Dwg Rev updated	KJ/JM	

**PARTS LIST:**

Qty	Part Number	Description
X	D205-596-105	CROSSTUBE ASSEMBLY, HI-HI FWD
1	D6005-180	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) MATERIAL: MANUFACTURE FROM D6005-180  
FINISHED LENGTH =  $134.40 \pm 0.02$
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH  
VIBRATING STYLUS
- 7) WEIGHT: 40 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO  
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE  
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS  
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT  
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT  
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION  
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1  
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE  
CROSSTUBE SUPPORT.  
**NOTE:** IT IS ACCEPTABLE TO SUBSTITUTE MS21920-25 CLAMPS WITH LONGER (MS21920-26) OR  
SHORTER (MS21920-24) CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A  
MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
44381

RELEASED  
06-01-16

B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-851 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-450 CUSHION; MS21920-25 WAS MS21920-24	MB	07.12.03
A	NEW ISSUE	DS	02.11.20
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D205-596-105	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE ASSEMBLY, HI-HI FWD	NTS
DATE	07.12.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



